

Work Order ID 102787

June-12-13 9:14:06 AM

102787

Page 1

Item ID: 647.9412

Revision ID:

Item Name: Deflector Upper, Half

Start Date: 6/11/13

Start Qty: 44.00

Required Date: 6/11/13

Req'd Qty: 44.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: 13-06-12 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.9400	A								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Billet size: 2.750" X 4.500" X 34.000"								
	1-Machine per folio FB184								
	DWG REV: <u>A</u>								
	FOLIO REV: <u>AA</u>								
	2- deburr and break all sharp edges								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

DA 13/07/14
OK 13/07/16

52

DA 13/07/14
OK 13/07/16

52

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Item ID: 647.9412 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Deflector Upper, Half
 Start Date: 6/11/13 Start Qty: 44.00 ***44*** Cust Item ID:
 Required Date: 6/11/13 Req'd Qty: 44.00 ***44*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				52			13-7-22
131 *131* HandFinish Hand Finishing	Memo CLEAN AND REMOVE ALL PART MARKING	0.00 0.00				52			13-7-24
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG: 20678 1- Black Anodize as per Dwg 647.9400 Certification of Comformity is required	0.00 0.00							13-07-24

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Item ID: 647.9412

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Deflector Upper, Half

Start Date: 6/11/13 Start Qty: 44.00

44

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 44.00

44

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Receive & Inspect for Damage & Mat'l Certs.

0.00

150

Packaging

Memo

0.00

Packaging

R 13/5/13 (14)

155 QC5- Inspect part completeness to step on W/O

0.00

155

QC

Memo

0.00

Quality Control

DAS
27
9-89

B 9-6

14

180 Identify as per dwg & Stock Location: 418

0.00

180

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

14

D 33 13-09-06

0.4

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Item ID: 647.9412

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deflector Upper, Half

Start Date: 6/11/13 Start Qty: 44.00

44

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 44.00

44

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

13/9/9

Picklist Print

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Work Order ID: 102787

Parent Item: 647.9412

Parent Item Name: Deflector Upper, Half

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 44.00

Required Qty: 44.00

Comments: IPP REV:A NEW ISSUE JFS 13/05/24 VERIFY BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B3.000X04.500 7075-T6 BAR 3.000" X 4.500"		Purchased	No			110	f	34.0000	2.834	124.696		13/07/14	

Location

Loc Qty

Loc Code

MAT

34

125362

34

→ 126133

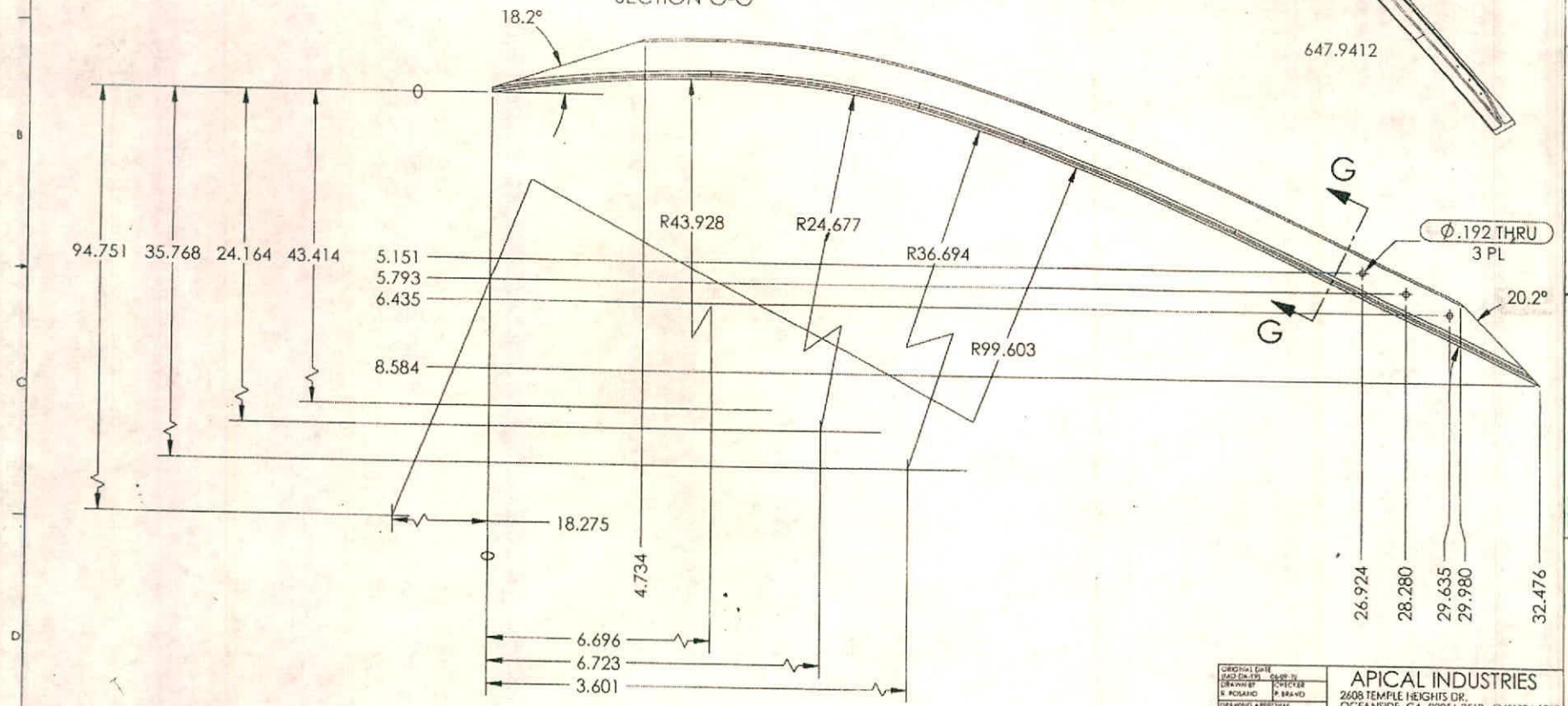
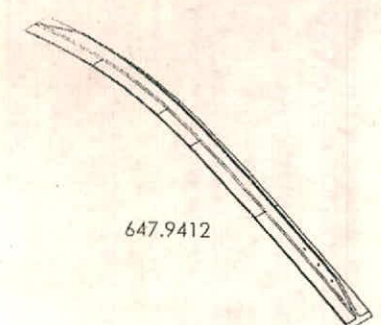
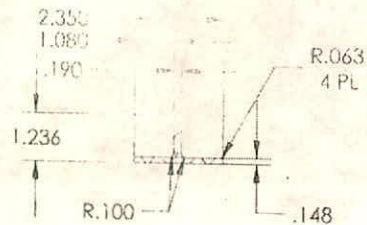
23.8

(8 billets)

~~124.6666~~

→ 124.6666 ft (44 billets)

102787



ORIGINAL DATE 10/20/78		DRAWN BY P. KOSAKO		CHECKED BY P. KOSAKO	
DESIGNED BY P. KOSAKO		APPROVED BY P. KOSAKO		CONTRACT NO.	
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300					
DEFLECTORS					
SHEET NO.	07M26	DWG. NO.	647.9400	REV.	A
SCALE: NONE				SHEET 6 OF 9	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62606

Date: 06-Sep-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

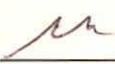
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
14 ea	Part: 647.9412 HARD ANODIZE BLACK MIL-A-8625 TYPE II CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130547	Rev:	Line:
<p>Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p>ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>6/9/13</u></p> <p>CERTIFIED SIGNATURE : <u></u></p> <p>RECEIVER SIGNATURE : _____</p>			

